

Date:
User:

Dart Aerospace Ltd.

Date: Tuesday, 12/20/2005 3:31:49 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 25316
Estimate Number : 10265
P.O. Number : NIA
This Issue : 12/20/2005 S.O. No. : NIA
Prsht Rev. : NC
First Issue : 12/20/2005 Type : LANDING GEAR
Previous Run : 25315
Written By : SEE COMMENT BELOW
Checked & Approved By :
Comment : Est Rev:l 02.09.25 Rearranged procedure steps KJ

Drawing Name : 350 SKIDTUBE ASSEMBLY RH
Part Number : D350636012
Drawing Number : D2750 REV C1
Project Number : N/A
Drawing Revision : C1
Material : NIA
Due Date : 1/20/2006 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 001

2.0 D26003BENT

Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

B25384

Pm' 06-03-09 (1)

3.0 D2744

Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2744

Cap

B 24672 BE 06-05-02 (1)

4.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-3-Bent aft end to length as per Dwg D2750 Mark cut line using Jig DT 8150. Deburr end Pm' 06-03-09 (1)

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1) and mark fwd end for cutting using Drill Jig DT 8150. Second side of Detail B to be Drilled using DT 8330 Pm' 06-03-09 (1)

3-Open up holes for Detail B, D and 2 aft 0.500" AE holes to finished size as per Dwg D2750 and DEO 9133 Do not open any 0.625" AE holes to finished size Pm' 06-05-01 (1)

4-Drill pilot holes as per Dwg D2750 (Sheet 3, D2750-2), mark Fwd end for cutting using Drill Jig Pm' 06-05-01 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP					Approval	Approval

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:31:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25316

Part Number: D350636012

Job Number:



Seq. #: Machine Or Operation: Description :

8.0 D2743 Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 D2743 Crossbolt spacer

225838 BE 06-05-04 (1)

9.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open 0.625" AE holes and countersink for welding crossbolt spacers as per Dwg D2750. Do not use cutting oil *fm 06-05-03 (1)*

2-Deburr and blow out all chips from inside of tube *fm 06-05-03 (1)*

3-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

M100480

Sikaflex expire date: *06-11-01*

fm 06-05-03 (1)

4-Weld crossbolt spacers D2743 as per Dwg D2750 and QSI 004

A/R Aluminum Rod

M19101 BE 06-05-04 (1)

5-Grind welds flush as per Dwg D2750 *fm 06-05-04 (1)*

6-Spot face ground handling holes AE0.750" (8 places) *fm 06-05-04 (1)*

7-Deburr holes

fm 06-05-04 (1)

10.0 QC5/9 WELD INSPECTION



Comment: Inspect weld and work to Step 20

06-05-08 (1)
PD 06-05-09

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

A-m 06-06-13 (1)

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

DC 06-06-14 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:31:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25316

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D27422

Blade Fitting, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2742-2	Blade Fitting, LH	B29640

14.0

AN835A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN8-35A	Bolt	m18576

15.0

AN960JD816

1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960JD816	Washer	M6956

16.0

MS21083N8

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21083N8	Nut	m19099

17.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
5	D2648-3	Wearpad	B25904

18.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-13	Wearplate	B25914

Q. M 06-06-15 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:31:51 PM
User: Kim Johnston

Process Sheet

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Customer: CU-DAR001 Dart Helicopters Services

Part Number: D350636012

Job Number: 25316

Job Number:



Description :

Seq. #:

Machine Or Operation:

29.0

A3235020935

Washer - Countersunk



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Plug

Batch

8 A3235-020-935

M18349

Nut

30.0

MS21042L3



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Nut

Batch

4 MS21042L3

M100393

Bolt

31.0

AN36A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Bolt

Batch

4 AN3-6A

M100274

Washer

32.0

AN960JD10



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Washer

Batch

4 AN960JD10

M100151

HAND FINISHING RESOURCE #1

33.0

HAND FINISHING1



Comment: HAND FINISHING RESOURCE #1

1-Assemble as per Dwg D2750 Page 4 Detail P. Install D2742-2 and seal with Sikaflex adhesive prior to installing aft most wearpad. Ensure holes are properly aligned.

A/R

Sikaflex-291

Sikaflex expire date: *06-11-06*

2-Install inserts & wearplates as per Dwg. D2750 Detail K & Q and IIN-D350-636 Page 4. Use a drop of Sikaflex in insert holes before installing wearpad/wearplate. AN3-6A bolts are installed AFT.

A/R

Sikaflex-291

Sikaflex expire date: *06-11-06*

a.m 06-06-16

Form: rprocess

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:
User:

Tuesday, 12/20/2005 3:31:51 PM
Kim Johnston

Process Sheet

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Customer: CU-DAR001 Dart Helicopters Services

Part Number: D350636012

Job Number: 25316

Job Number:



Description:

Seq. #:

Machine Or Operation:

3-Install D2745 Bushing as per Dwg. D2750 Detail M

4-Install A3235-020-935 Plug as per Dwg. D2750 Detail L

5-Install AN3-6A Bolt as per Dwg. D2750 Detail Q

INSPECT WORK TO CURRENT STEP

34.0

QC5



Comment: INSPECT WORK TO CURRENT STEP

35.0

PACKAGING 1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

36.0

D2741



Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Kit Picking

Qty Part Number

1 D2741

Description

Blade

Batch

B2593P ✓

37.0

AN960JD816



1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

2 AN960JD816

Description

Washer

Batch

M6956 ✓

38.0

MS21083N8



Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

2 MS21083N8

Description

Nut

Batch

M100998 ✓

Form: rprocess

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: SD Date: 06/06/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:31:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25316

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

AN816A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 AN8-16A

Bolt

M15432

Pick/27 (1)

40.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

A 06/06/27 (1)

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

REV D

Pick/27 (1)

42.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/27 (1)

Job Completion



U 06-06-27

Date: Tuesday, 12/20/2005 3:31:49 PM
 User: Kim Johnston

Process Sheet

3

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	350 SKIDTUBE ASSEMBLY RH
Job Number :	25316		
Estimate Number :	10265		
P.O. Number :		Part Number :	D350636012
This Issue :	12/20/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2750 REV C1
First Issue :	12/20/2005	Project Number :	N/A
Previous Run :	25315	Drawing Revision :	C1
		Material :	
Written By :		Due Date :	1/20/2006
Checked & Approved By :		Qty:	1
Comment :	Est Rev:1 02.09.25 Rearranged procedure steps KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 001

Jan 13/06

2.0	D26003BENT	Extrusion Bent
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent)

3.0	D2744	Fwd Cap
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2744 Cap

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-3-Bent aft end to length as per Dwg D2750 Mark cut line using Jig DT 8150. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1) and mark fwd end for cutting using Drill Jig DT 8150. Second side of Detail B to be Drilled using DT 8330

3-Open up holes for Detail B, D and 2 aft 0.500" AE holes to finished size as per Dwg D2750 and DEO 9133 Do not open any 0.625" AE holes to finished size

4-Drill pilot holes as per Dwg D2750 (Sheet 3, D2750-2), mark Fwd end for cutting using Drill Jig

REFERENCE ONLY